

Work Order ID 77468

December-08-11 8:00:30 AM

77468

Page 1

Item ID: D2989-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Lid Assembly
Start Date: 08/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 20/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 11/12/08 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: 1115778

11/12/14 (1x)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

11.12.14

1x 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

1XØm/4/12/16

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

Handwritten: 11/12/16

Handwritten: 8=400 F

Handwritten: 9=10

Handwritten: 1 BX 11-12-16

Handwritten: M119480

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 08/12/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 20/12/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

150

Packaging

Packaging

Memo

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

P11-12-20
①

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Picklist Print

December-08-11 8:00:35 AM

Page 1

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77468

Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2221-1

Manufactured

No

100

Each

16.0000

1

1

**

11/12/10

✓ *D2221-1*

Rib

Location

Loc Qty

Loc Code

WA006

16

71372

4

72297

12

(1x)

✓ D2989-3

Manufactured

No

100

Each

4.0000

1

1

**

11/12/10

D2989-3

Rib

Location

Loc Qty

Loc Code

WA005

4

71551

1

72408

3

(1x)

✓ D2989-4

Manufactured

No

100

Each

4.0000

1

1

**

11/12/10

D2989-4

Rib

Location

Loc Qty

Loc Code

WA005

4

71550

1

72409

3

(1x)

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Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D2989-5	Manufactured	No	100	Each	9.0000	2	**	2	11/12/10
D2989-5									
Rib									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			WA005	9					
			71222	9					
✓ D3182-1	Manufactured	No	100	Each	2.0000	2	**	2	11/12/10
D3182-1									
Hinge									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			WA005	2					
			71223	2					
✓ D3442-3	Manufactured	No	100	Each	7.0000	2	**	2	11/12/10
D3442-3									
Shim									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			WA005	7					
			70671	7					
D3827-041	Manufactured	No	100	Each	9.0000	1	**	1	11/12/10
D3827-041									
Rib Assembly (Inboard)									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			WA006	9					
			72083	3					
			72729	6					

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3832-5
D3832-5
Mesh (Lid)

Manufactured No

100 Each

5.0000

1

**

1
BY 11/12/14

Location

Loc Qty

Loc Code

WA

5

71302

2

73638

3

(1x)

✓ D3833-5
D3833-5
Mesh (Lid End)

Manufactured No

100 Each

48.0000

2

**

2
BY 11/12/14

Location

Loc Qty

Loc Code

WA

48

67461

48

(2x)

✓ D3838-041
D3838-041
Rib Assembly (Basket Lid, LH)

Manufactured No

100 Each

4.0000

1

**

1
BY 11/12/10

Location

Loc Qty

Loc Code

WA

4

71744

1

72414

3

(1x)

✓ D3838-042
D3838-042
Rib Assembly (Basket Lid, RH)

Manufactured No

100 Each

4.0000

1

**

1
BY 11/12/10

Location

Loc Qty

Loc Code

WA

4

71740

1

72415

3

(1x)

December-08-11 8:00:35 AM

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Page 3

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77408 M.C.J
11/12/08

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3838-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-22/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS	DRAWING NO. D2989	
CHECKED	DS	REV. D SHEET 1 OF 5	
MFG. APPR.	DS	TITLE BASKET LID ASSEMBLY	
APPROVED	DS	SCALE NTS	
DE APPR.	DS	DATE 08.09.24	
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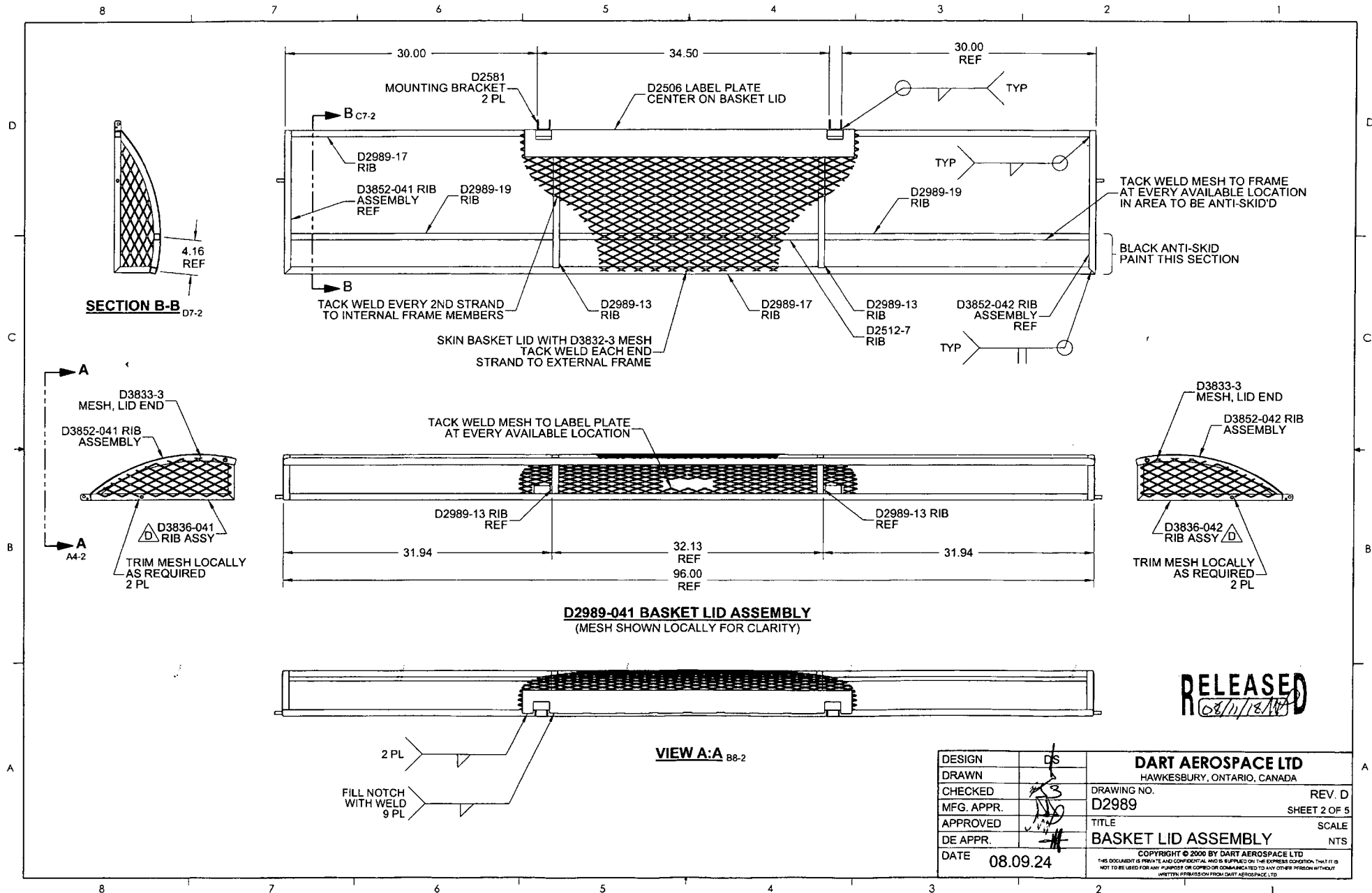
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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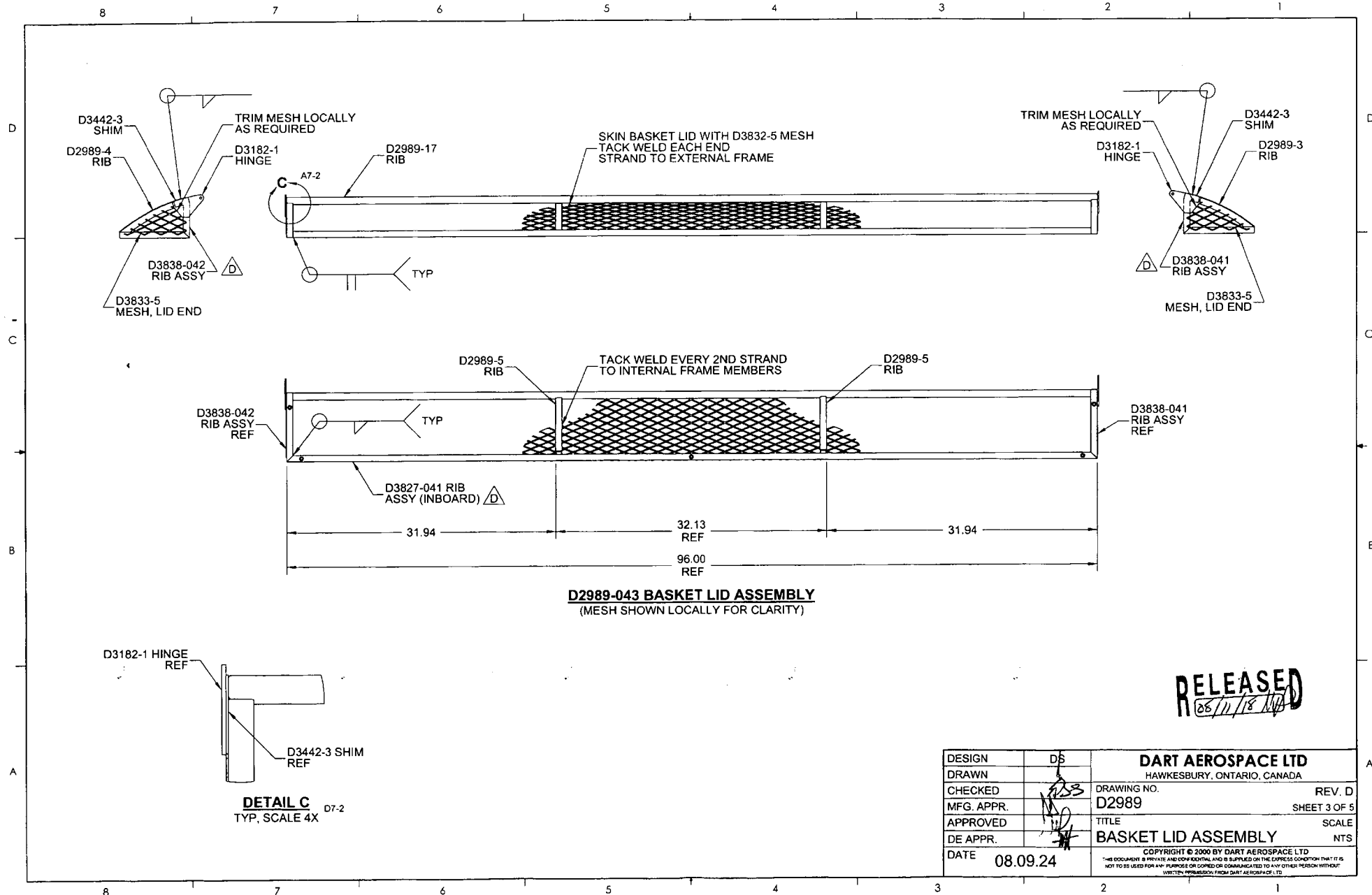
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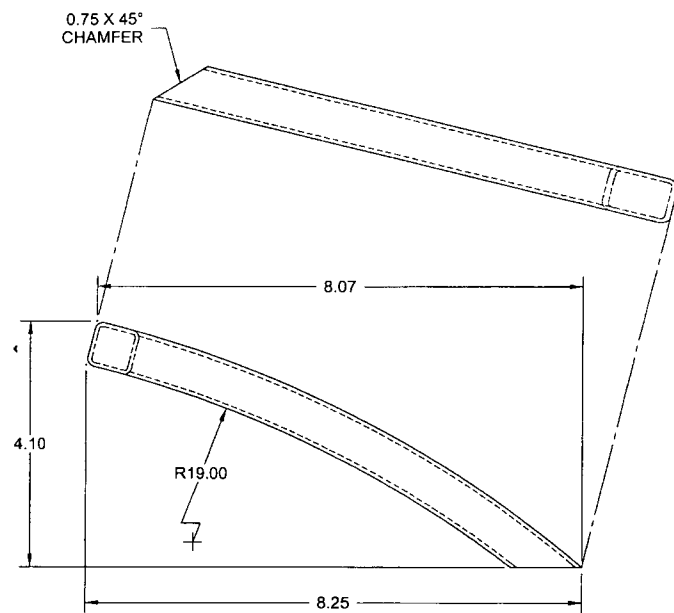
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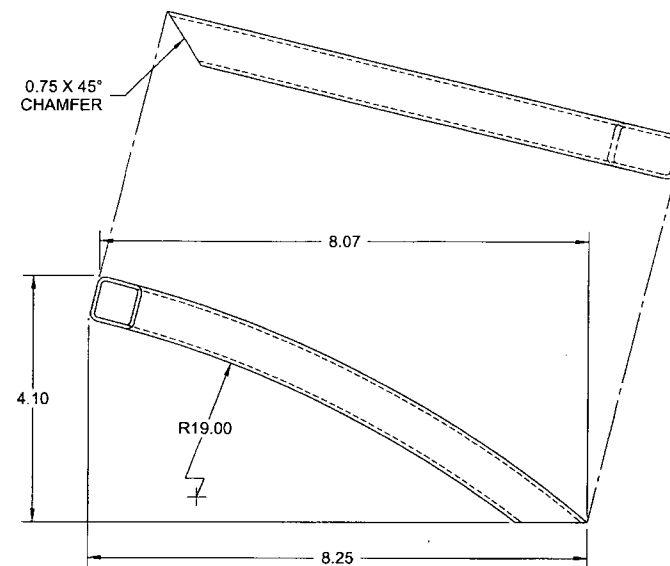
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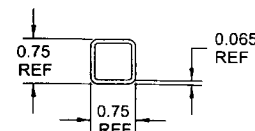
77468



D2989-3 RIB



D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		BASKET LID ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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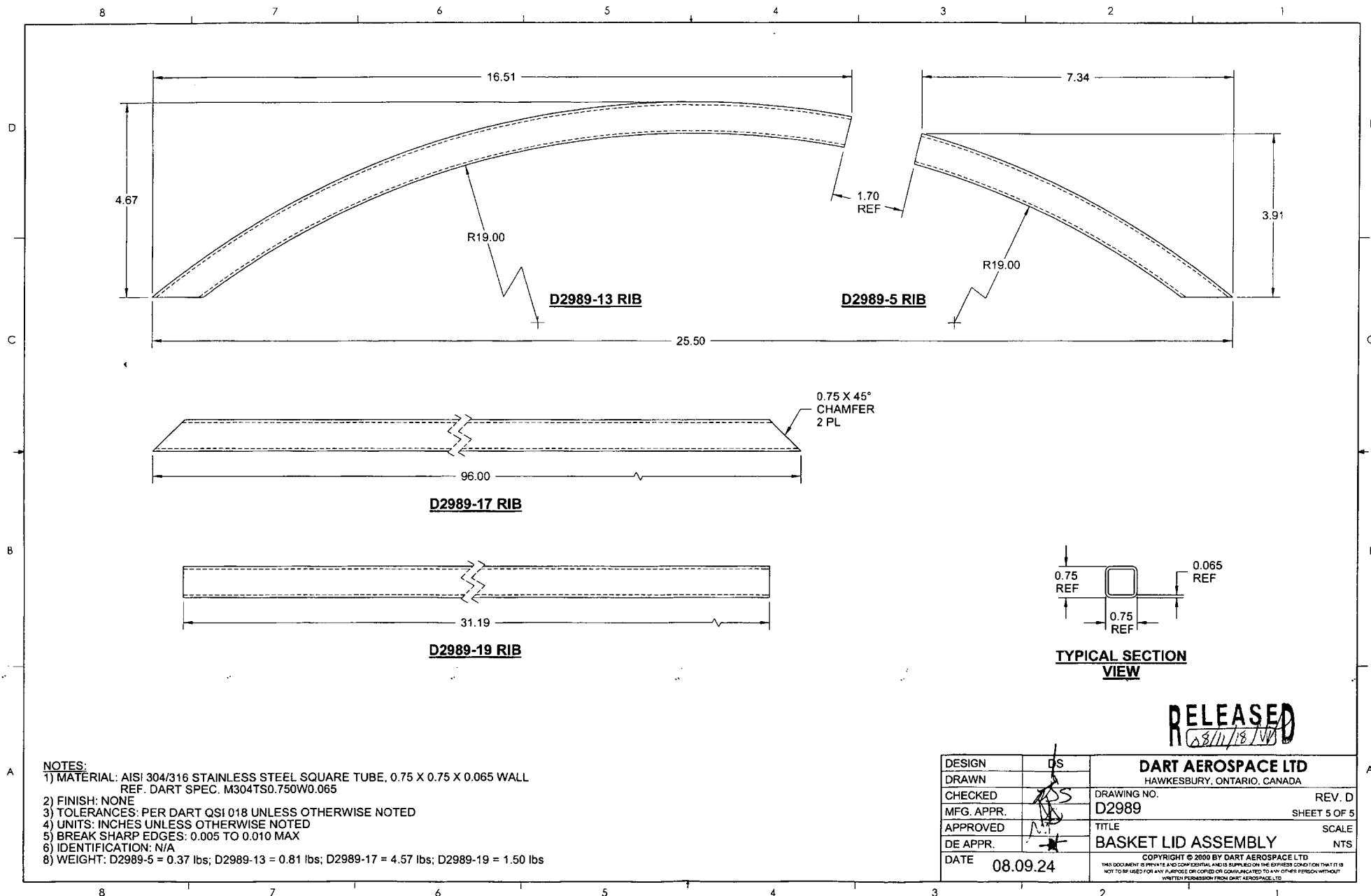
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